

Work Order ID 67357

Wednesday, March 16, 2011 11:57:08 AM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 3/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-03-16

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2580-041	Rev.D DEO-D1

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG003

N/A

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

[Signature] 11-4-19

Wednesday, March 16, 2011 11:57:08 AM

Page 2



Accept

**Setup Start**

Stop



Start Date: 3/16/2011 **Start Qty:** 1.00

**Cust Item ID:**

Required Date: 3/23/2011 **Req'd Qty:** 1.00



Customer:

Reference:

Run Start



Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID

Tool #**Plan
Code**

Accept
Qty

Reject
QtyReject
Number

**Insp.
Stamp**

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends and remove bending marks

2- Prepare tube for swaging as per QSI 002

130

QC5- Inspect part completeness to step on W/O

0.00



OC

Memo

0.00

Quality Control

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Item ID: D205-634-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Skidtube

Start Date: 3/16/2011 Start Qty: 1.00

Required Date: 3/23/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R□□□ Aluminum Rod

2-Grind welds on step as per Dwg D2580

3-Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002
and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start
expansion and finish with 1/2 x 18G to achieve dwg dimension.4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Debur

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

+ C-Base

QC10- Inspect visual per QSI004- ground welds

0.00

150



QC

Quality Control

Memo

0.00

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Item ID: D205-634-041

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Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 3/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 ul04/28

170

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

m-k

11/04/26

(1X)

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:
OVEN TEMPERATURE:
FINISH TIME:

1:20
320°F
1:50

m-k

11/04/26

(1X)

N116964

Work Order ID 67357

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Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 3/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00



0.00

QC

Memo

Quality Control

S. Morley

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Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 3/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

0.00



HandFinish

Hand Finishing

Memo

0.00

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R ☐ ☐ ☐ Sikaflex-291 ☐ 116918

Sikaflex expire date: 12/15/01

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

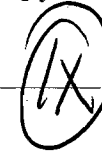
4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R ☐ ☐ ☐ Sikaflex-291 ☐ 116918

Sikaflex expire date: 12/15/01

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: 117315

m-d
11/04/30

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Item ID: D205-634-041

Accept

Revision ID:

Item Name: Replacement Skidtube

Start Date: 3/16/2011 Start Qty: 1.00

Required Date: 3/23/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

0.00

8/1/05/02

(4)

220



Packaging

Packaging

Packaging

0.00

Memo

Identify and pack for shipping as per PPPD205-634-041

Location:

PPP Rev:

PPP 67877

0.00

4/1/06

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

4/15/06

4/15/06

Picklist Print

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Page 1

Work Order ID: 67357

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 3/16/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30
KJ IPP Rev P 10.02.19
per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q
10.12.01 as per chg003 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D202-1 Spacer	D2579	Manufactured	No			140	Each	504.0000	20	20			

Location	Loc Qty	Loc Code
LG	179	
67308	179	
LG002	325	
65529	13	
66121	1	
66929	110	
67129	201	

D2580-1		Manufactured	No			110	Each	7.0000	1	1			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

205 Skidtube bent detail

Location	Loc Qty	Loc Code
LG	7	
59856	1	
66727	1	
66728	1	
67075	2	
67076	2	

BE 11/04/26
B62400 x20

11-4-19

Picklist Print

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Page 2

Work Order ID: 67357

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 3/16/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

D2576-3 Manufactured No

140 Each

29.0000

1 1



Step (maching detail)

Location

Loc Qty

Loc Code

LG

29

52215

29

D2855 Manufactured No

200 Each

80.0000

1 1



Cap

Location

Loc Qty

Loc Code

FP6

1

56613

1

fp7

9

65519

9

ST024

70

50513

1

50770

28

51539

2

53791 ✓

4

65569

35

AN3-5A Purchased No

200 Each

689.0000

2 2



Bolt

Location

Loc Qty

Loc Code

ST350

689

115016 ✓

23

115371 ✓

500

116632

166

BE 11/04/30

M-H 11/04/30

M-H 11/04/30

IX

Wednesday, March 16, 2011 11:57:27 AM

Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 67357

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 3/16/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD10L NAS1149D0332J Purchased

No

200

Each

4.0000

2

2



Washer

Location

Loc Qty

Loc Code

ST335

4

11912

4

ALS7-1032-130 Purchased

No

200

Each

1,538.000

50

50



Insert

Location

Loc Qty

Loc Code

FP

21

115079

21

ST282

1517

113238

17

115502

500

116800

1000

AN3C4A Purchased

No

200

Each

2,957.000

50

50



BOLT

Location

Loc Qty

Loc Code

ST350

2957

115300

25

116075

337

116924 ✓

1200

117010

395

117094

1000

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Work Order ID: 67357

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 3/16/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

AN960C10L NAS1149C0332 Purchased No

200 Each

-19.0000 50 50


washer

Location

Loc Qty

Loc Code

ST297 -19
107534 -21
108246 2

117291



M-L 11/04/30
50X

D3566-13 Manufactured No

200 Each

53.0000 1


Gasket

Location

Loc Qty

Loc Code

FP011 36
66550 ✓ 36
FP014 17
66137 17



M-L 11/04/30
1X

D3566-5 Manufactured No

200 Each

32.0000 1


Gasket

Location

Loc Qty

Loc Code

FP015 32
63574 1
65528 10
66146 1
66552 20

67589



M-L 11/04/30
1X

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Page 5

Work Order ID: 67357

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 3/16/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

D3566-1 Manufactured No

200 Each

34.0000

2

2



Gasket

Location

Loc Qty

Loc Code

68344

FP	20
66548	20
FP011	11
65525	11
FP015	3
57715	1
66040	1
66129	1



m-h 11/04/30
2x

D3564-11 Manufactured No

200 Each

25.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

68350

FP019	25
65159	1
66154	16
66554	8



m-h 11/04/30
1x

D3564-13 Manufactured No

200 Each

63.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP16

66549	40
66805	18
	22
FP17	23
59660	1
66136	22



m-h 11/04/30
1x

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Page 6

Work Order ID: 67357



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 3/16/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-9

Manufactured No

200

Each

23.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP

1

55334

1

FP019

21

65524

13

66153

8

FP19

1

62238

1

67590



m-h 11/04/30
IX

D3564-5

Manufactured No

200

Each

36.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FG

1

34806

1

FP19

24

57525

1

58709

1

66551

22

FP-19

11

63575

1

66148

10

~~68560~~ 68960



m-h 11/04/30
IX

Picklist Print

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Work Order ID: 67357



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 3/16/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

D2594-3

Manufactured No

200

Each

839.0000

16

16



O-Ring, 205 Skidtube

Location

66952

Loc Qty

Loc Code

FP	543
55546	19
58191	12
59358	12
65518	500
fpa	296
61762	296



m.h 11/04/30
16x

D2594-1

Manufactured No

200

Each

568.0000

16

16



Plug, 205 Skidtube

Location

Loc Qty

Loc Code

FP	483
42807	112
55002	71
66122	300
FP14	85
58434	15
65512	37
65980	33



m.h 11/04/30
16x

66932

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Shop Packet Print

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DART**RELEASED**
07-06-28 #D**DEO ATTACHED**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 01357
0711-03-16

GENERAL NOTES:

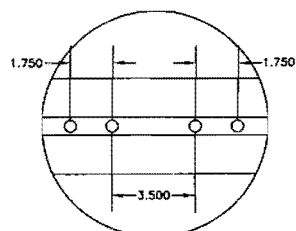
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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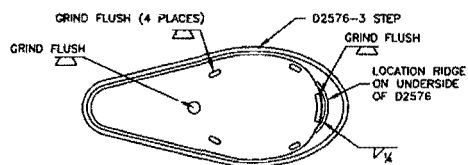
W/D 67357

DETAIL A
SCALE 5:24

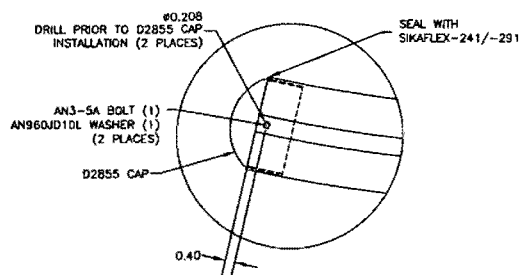


RELEASED
07.06.28-4

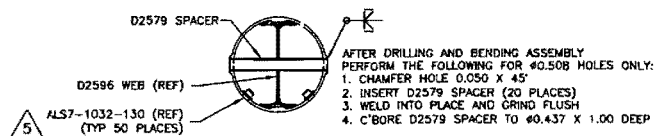
DETAIL B
SCALE 5:24



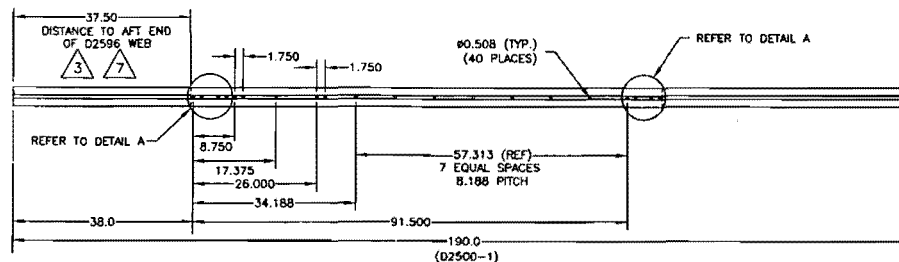
DETAIL C
SCALE 5:24



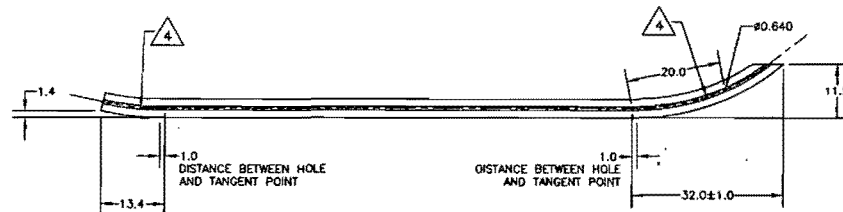
SECTION D-D
SCALE 5:24



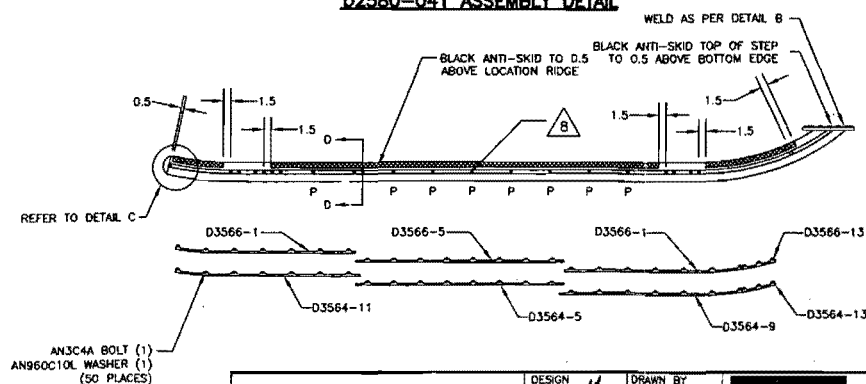
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



D2580-041 NOTES

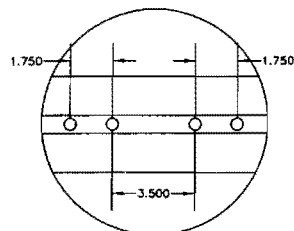
- i) FINISH: ACID ETCH, ALODINE PER DART OSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART OSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART OSI 005 4.4

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. WILLOWBURRY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. 0
DATE	TITLE	D2580	SHEET 2 OF 3
07.02.27	205 SKIDTUBE ASSEMBLY	SCALE	1:24

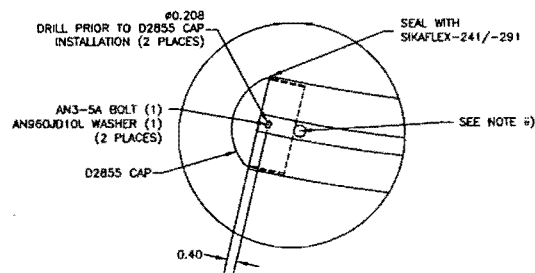
DETAIL E
SCALE 5:24



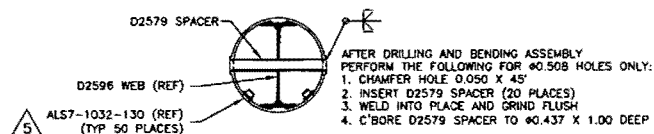
RELEASED
07-06-28

DEO ATTACHED

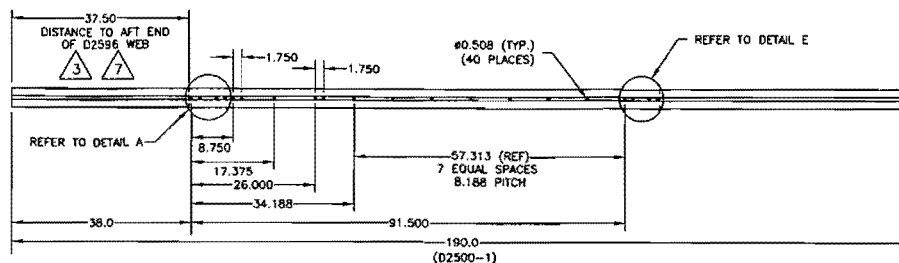
DETAIL G
SCALE 5:24



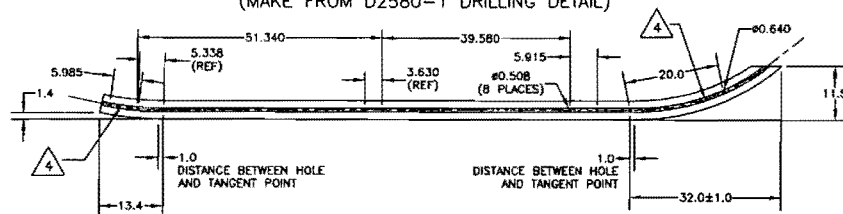
SECTION H-H
SCALE 5:24



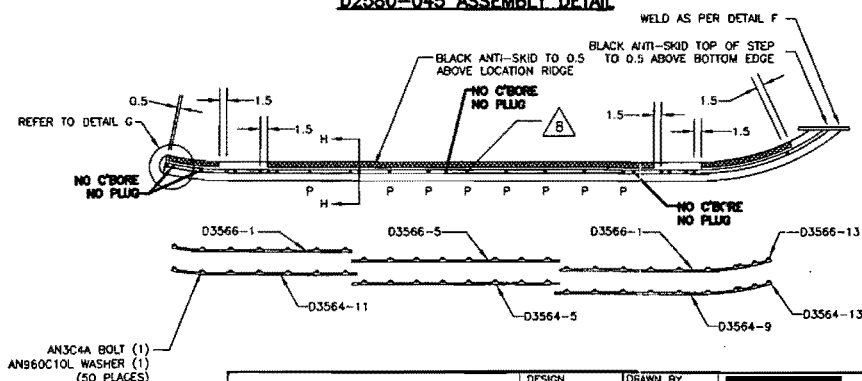
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



D2580-045 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION

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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DESIGN	<i>PH</i>
CHECKED	<i>[Signature]</i>
DATE	07.02.27

DRAWN BY	<i>RH</i>
APPROVED	<i>HA</i>

DART		DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA	
DRAWING NO. D2580		REV. SHEET 3 OF 3	
TITLE 205 SKIDTUBE ASSEMBLY		SCALE AS SHOWN	

W6 67357

DRAWING NO. D2580	TITLE 205 SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2580-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN UP	CHECKED L	MFG. APPR. E	APPROVED MP		DE APPR. H		
DATE 10.09.22	DATE 10.11.04	DATE 10.11.04	DATE 10/11/04		DATE 10.11.04		

PURPOSE:

CHANGE ALL WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

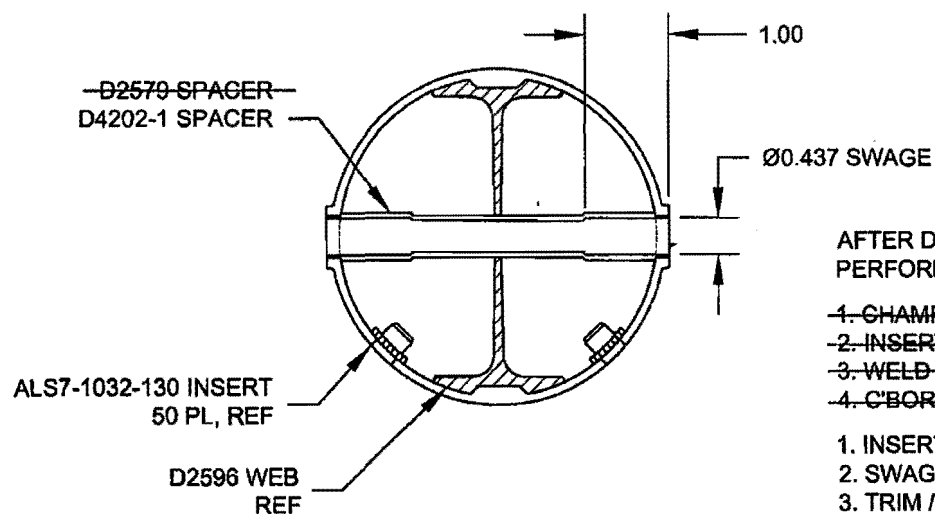
WAS

QTY -041	QTY -045	PART NUMBER	DESCRIPTION
20	24	D2579	CROSS BOLT SPACER

IS

20	24	D4202-1	SPACER
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SECTION D-D & SECTION H-H ARE AMENDED AS FOLLOWS:



SECTION D-D
NOT TO SCALE

SECTION H-H
NOT TO SCALE

RELEASED
2010-11-18
MP

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

1. INSERT D4202-1 SPACER, 20 PL (-041) OR 24 PL (-045)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

Linda Lacelle

From: dshepherd@dartaero.com
Sent: April 18, 2011 11:36 AM
To: Linda Lacelle; Mike Petsche
Cc: Bill Beckett; 'Chris Provencal'; 'Eric Charbonneau'
Subject: Re: Alum. Solution Anneal - swaging

Makes sense to me ... We don't want to get caught short ... Make sure that if we do this, they are identified with the old CHG number.

David

Sent from my BlackBerry device on the Rogers Wireless Network

From: "Linda Lacelle" <llacelle@dartaero.com>
Date: Mon, 18 Apr 2011 11:21:10 -0400
To: 'Mike Petsche' <mpetsche@dartaero.com>; <dshepherd@dartaero.com>
Cc: 'Bill Beckett' <bbeckett@dartaero.com>; 'Chris Provencal' <cprovencal@dartaero.com>; 'Eric Charbonneau' <echarbonneau@dartaero.com>
Subject: RE: Alum. Solution Anneal - swaging

I am ready to weld some up, I don't want to get into trouble with L/T's on these, any objections??
LL

From: Mike Petsche [mailto:mpetsche@dartaero.com]
Sent: April 18, 2011 10:42 AM
To: 'Linda Lacelle'; dshepherd@dartaero.com
Cc: 'Bill Beckett'; 'Chris Provencal'; 'Eric Charbonneau'
Subject: RE: Alum. Solution Anneal - swaging

Well I'm not sure what to say.

CO7
CHG ~~CO7~~ D2579

It is my understanding that the swaging will still make sense even with the extra hoops we need to jump through.

If there is still uncertainty on the delivery of the material, we CAN still weld them if we need to.

And while this might be less than "world class", couldn't we take some of our tubing that we have in stock and zap it with the welder to knock down the temper a little? Ground clamp on one end, torch on the other.....BZZZZZZT.

(I'm only sort of joking....because I bet it would work)

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: April 18, 2011 9:44 AM
To: dshepherd@dartaero.com; 'Mike Petsche'
Cc: Bill Beckett; Chris Provencal; Eric Charbonneau
Subject: RE: Alum. Solution Anneal - swaging
Importance: High

So any thoughts about going fwd for now with 205's? We are down to 6, and I don't want to run out as we have orders for these for early May.

LL

From: Linda Lacelle [mailto:llacelle@dartaero.com]

Sent: April 12, 2011 8:11 AM

To: dshepherd@dartaero.com; 'Mike Petsche' (mpetsche@dartaero.com)

Cc: Bill Beckett (bbeckett@dartaero.com); Chris Provencal (cprovencal@dartaero.com); Eric Charbonneau (echarbonneau@dartaero.com)

Subject: FW: Alum. Solution Anneal - swaging

So if we send them 400 pcs of the 6061T6 tube, they can temper it to T4 for a cost of 1850.00...

LL

From: John Spencer [mailto:johns@metcor.biz]

Sent: April 12, 2011 8:04 AM

To: llacelle@dartaero.com

Subject: Alum. Solution Anneal

Linda,

Metcor could process the tubes within a few days after receiving.

Price for the lot is \$1850 including conductivity test.

Would prefer 8 inch cut to length, if not we could manage 4 " lengths .

Please let me know and contact me on my cell.

Regards,

John Spencer

Metcor Inc.

Nadcap Certified

johns@metcor.biz

514-386-1620

NO. 249

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 67531
Part number: D205 634 041
Description: 205
Welding Process: Tig ☒ Mig ☐
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Rat Gump Date of Test Coupon 11.04.25
Welder Barclay Elliott Date of Test Coupon 11.04.25

The above named individual is qualified in accordance with AWS D17.1.2001 to weld